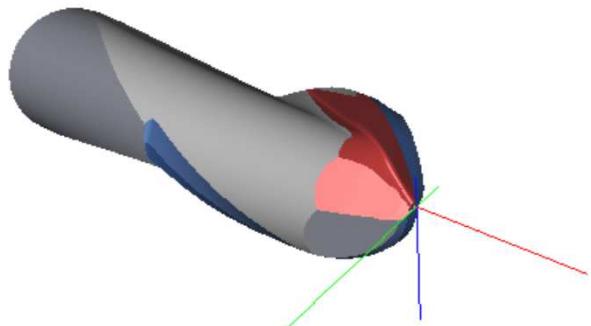


Ball nose endmill Ø4 Z2

A01-212

This is sharpening example for ball nose endmill with Radius 2. The dimensions were found using caliper. The tool program was taken out of database.



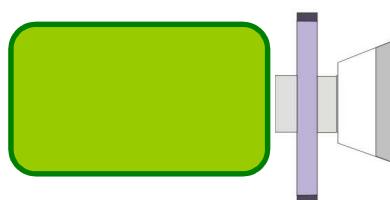
1. Cycletime for Resharpening

Workpiece:	Diameter 4 mm, Z 2, Length of cutting edge 9 mm, Helix angle 30° Material CARBIDE				
Operations	Probe	Gashing	O.D.2	O.D.1	Chamfer
Feed [mm/Min]	2000	100	150	400	150
Power [kW]		2	1	2	1
Cutting speed [m/s]		32	32	32	24
Used wheels		1	2	2	2
Grinding time [s]	6	14	148	62	13
Total cycle time	4 Min 3				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	11V9 Ø100 D64



1 2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA / ARIES Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories:

Responsible engineer: SIW. 24.5.13

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, UK, China

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